

ABSTRACT OF THE DISCLOSURE

A strip rolling mill includes a pair of upper and lower work rolls for rolling a strip, intermediate rolls for supporting each of the paired work rolls, and back-up rolls for supporting each of the intermediate rolls. Each of the work rolls is provided with a tapered portion at a vicinity to one end thereof in such a way that the tapered portions of the work rolls are on opposite sides of roll bodies thereof with respect to roll axis directions. The rolling method for the strip rolling mill comprises the steps of: when the material with a constant width is being rolled, setting axial positions of the work rolls at appropriate positions and changing axial positions of the intermediate rolls to control a thickness distribution in a width direction of the material being rolled. This arrangement significantly improves an edge drop and at the same time minimizes edge drop variations, thereby preventing surface defects from occurring on the surface of the material being rolled and performing an efficient rolling operation.